



SPLICING INSTRUCTIONS FOR LIGHTWEIGHT BELTING

ITEM	ITEM DESCRIPTION	TOP PLATEN TEMPERATURE	BOTTOM PLATEN TEMPERATURE	TIME IN MINUTES	PRESSURE IN LBS	RECOMMENDED CEMENT HOT	RECOMMENDED CEMENT COLD	RECOMMENDED SPLICE TYPE	PRESS BUILD UP	SPECIAL SPLICING MATRIX	NOTES
1653(34)(1-1).008	3-ply tan SBR transmission	305	305	35	40	1-2-4	3-4-5	S/A	1		
1654(34)(1-1).008	4-ply tan SBR transmission	305	305	35	40	1-2-4	3-4-5	S/A	1		
1613(8-34)(0-1).008	3-ply SBR HS&W	300	310	35	40	1-2-4	3-4-5	S/A	1		
1614(8-34)(0-1).008	4-ply SBR HS&W	300	310	35	40	1-2-4	3-4-5	S/A	1		
16(0-1)3(34)(3S-1).008	3-ply white silicone HS&W (SBR carcass)	315	315	35	40	1-2-4-6	3-4-5	S/A	1		*1 add bead of RTV silicone to cover
6633(81)(1-1).008	3-ply brown NBR Sheeting	305	305	35	35	1-2	4	S/A	1		
6635(81)(1-1).008	5-ply brown NBR Sheeting	305	305	35	35	1-2	4	S/A	1		
6637(81)(1-1).008	7-ply brown NBR Sheeting	305	310	40	35	1-2	4	S/A	1		
6614(15)(1-1).020	4-ply black NBR on poly fx by fx	310	310	40	35	1-2	4	S/A	1		
2624(44-78)(44-1).010	4-ply amber neoprene Chemglide	305	305	40	35	1-2-4	4	S/A	1		
36(5-8)5(81)(0-0).006	5-ply natural rubber tobacco TDL	310	310	35	35	1-2	4	S/A	1		
36(5-8)7(81)(0-0).006	7-ply natural rubber tobacco TDL	310	310	35	35	1-2	4	S/A	1		
6614(21)(0-0).016	4-ply black NBR on RFL poly/nylon bare by bare	310	310	40	40	1-2-4	3-4	S/A	1		
6615(21)(0-0).013	5-ply black NBR on RFL poly/nylon bare by bare	310	310	40	40	1-2-4	3-4	S/A	1		
6602(30)(4B-1).015	2-ply white NBR on RFL poly 3/64" by fx	295	305	35	35	1-2	4	S/A	1		sanded / bevel
6603(30)(4B-1).015	3-ply white NBR on RFL poly 3/64" by fx	295	305	35	35	1-2	4	S/A	1		sanded / bevel
6602(18)(4-1).015	2-ply white NBR on RFL poly/nylon 3/64" by fx	295	305	35	35	1-2	4	S/A	1		sanded / bevel
6603(18)(4-1).015	3-ply white NBR on RFL poly/nylon 3/64" by fx	295	305	35	35	1-2	4	S/A	1		sanded / bevel
6653(18)(4-1).015	3-ply tan NBR on RFL poly/nylon 3/64" by fx	300	310	40	35	1-2	4	S/A	1		sanded / bevel
6602(79-60)(21-1).015	2-ply white NBR Teflon® on poly by fx	305	305	35	40	1-2	4	S/A	1		
6603(79-60)(21-1).010	3-ply white NBR Teflon® on poly by fx	305	305	35	40	1-2	4	S/A	1		
5603(30)(3-1).010	3-ply white butyl on poly 1/32" by fx	305	305	35	35	1-2	4	S/A	1		sanded / bevel
1683(24)(37A-0).015	3-ply natural SBR rougtop on RFL poly by bare	310	310	40	40	1-2-4	3-4	S/A	2	X	bevel / wire wheel
1652(24)(37A-0).040	2-ply tan SBR rougtop on RFL poly by bare	305	310	40	40	1-2	3-4	S/A	2	X	bevel / wire wheel
1612(24)(37A-0).040EC	2-ply black SBR rougtop on RFL poly by bare	305	310	40	40	1-2	4	S/A	2	X	bevel / wire wheel
6613(24)(37A-0).025MOR	3-ply black MOR rougtop on RFL poly by bare	310	310	40	50	1-2-4	4	S/A	2	X	bevel / wire wheel
1682(24)(37A-0).040	2-ply natural SBR rougtop on RFL poly by bare	305	305	40	40	1-2-4	4	S/A	2	X	bevel / wire wheel
6633(18)(37A-0).015	3-ply brown NBR rougtop on RFL poly/nylon by bare	305	310	40	40	1-2-4	4	S/A	2	X	bevel / wire wheel
6633(78)(37A-1).010	3-ply brown NBR rougtop on cotton/poly by bare	305	305	40	40	1-2-4	4	S/A	2	X	bevel / wire wheel
3683(19)(37A-0).020	3-ply natural rubber rougtop on RFL poly/nylon by bare	300	310	40	40	1-2-4	4	S/A	2	X	bevel / wire wheel
3682(24)(37A-0).040	2-ply natural rubber rougtop on RFL poly by bare	300	310	40	40	1-2-4	4	S/A	2	X	bevel / wire wheel
6603(30)(57-1).015	3-ply white NBR on RFL poly Neatgrip by fx	300	305	35	35	1-2	4	S/A	2	X	sanded / bevel
6602(30)(57-1).015	2-ply white NBR on RFL poly Neatgrip by fx	300	305	35	35	1-2	4	S/A	2	X	sanded / bevel
6603(18)(69-1).010	3-ply white NBR Meatcleat on RFL poly/nylon by fx	300	305	35	40	1-2-4	4	S/A	3		*2 match ribs / filler strips
3612(24)(52-0).055	2-ply black NR Diamond Top on RFL poly by bare	310	310	40	40	1-2-4	3-4	S/A	2	X	bevel / wire wheel
36(5-1)3(24)(52-0).040	3-ply tan/black NR Diamond Top on RFL poly by bare	310	310	40	40	1-2-4	3-4	S/A	2	X	bevel / wire wheel
36(5-1)2(24)(52-0).055	2-ply tan/black NR Diamond Top on RFL poly by bare	310	310	40	40	1-2-4	3-4	S/A	2	X	bevel / wire wheel
1613(34)(68-1).008	3-ply black SBR Chemclimb on cotton/poly by fx	310	310	40	40	1-2	3-4	S/A & S	3	X	square top / angled bottom
1683(34)(68-1).008	3-ply tan SBR Chemclimb on cotton/poly by fx	310	310	40	40	1-2	3-4	S/A & S	3	X	square top / angled bottom
1612(24)(68-0).040	2-ply black SBR Chemclimb on RFL poly by bare	310	310	40	40	1-2	3-4	S/A & S	3	X	square top / angled bottom
1613(34)(71-1).008	3-ply black SBR Chemridge on cotton/poly by fx	310	310	40	40	1-2	3-4	S/A & S	3	X	square top / angled bottom
66(20)3(79)(37X-1).015	3-ply orange XNBR rougtop on poly by fx	300	310	40	40	1-2-4	4	S/A	2	X	bevel / wire wheel
66(18-1)3(15)(37X-1).025	3-ply blue XNBR rougtop on RFL poly by fx	300	310	40	40	1-2-4	4	S/A	2	X	bevel / wire wheel
66(18-1)3(24)(37X-0).025	3-ply blue XNBR rougtop on RFL poly by bare	300	310	40	40	1-2-4	4	S/A	2	X	bevel / wire wheel
1613(24)(52-3B).040	3-ply black SBR Diamond Impression on RFL poly by cover	315	310	40	45	1-2-4	3-4	S/A	2	X	sanded / bevel angled step
1612(24)(4F-0).046	2-ply black SBR fabric impression on RFL poly by bare	305	300	35	35	1-2-4	3-4	S/A	2	X	sanded / bevel angled step
6602(79)(46-1).015	2-ply white NBR pyramidtop on poly by fx	305	300	35	40	1-2-4	3-4	S/A	2	X	sanded bevel angle step splice
1613(77-204)(0-0).040	3-ply black SBR quiet weave both sides on monofilament by bare	305	305	35	40	1-2-4	3-4	S/A	1		angle step cut
1612(204)(0-0).085	2-ply tan poly bare by bare, black SBR skim	305	305	35	35	1-2-4	3-4	S/A & S	1		split on angle / one step
1612(77-76)(0-0).040	2-ply black SBR quiet weave by bare on polyester	300	300	35	35	1-2-4	3-4	S/A & S	1		split on angle / one step
1612(76)(3F-0).065	2-ply black SBR fabric impression on RFL monofilament by bare	305	300	35	35	1-2-4	3-4	S/A & S	2	X	split sanded bevel angle step splice
1613(76)(0-0).050	3-ply black SBR on RFL monofilament bare by bare	305	305	35	40	1-2-4	3-4	S/A	1		angle step cut

CEMENTS

- 1 - BFG
- 2 - BLAIR RUBBER
- 3 - CONTI
- 4 - REMA TECH
- 5 - PANG
- 6 - RTV SILICONE WACKER
- 7 - PVC foil

SPLICE TYPE

- S/A - STEPPED ANGLE
- S/A & S- STEPPED ANGLE AND SQUARE TOP
- PRESS BUILD UP**
- 1 - PHENOLIC/TEFLON PAD/BELT + BUMPERS/TEFLON PAD/PHENOLIC
- 2 - PHENOLIC/TEFLON PAD/BELT + BUMPERS/MATRIX PAD/PHENOLIC
- 3 - SPECIAL (ADAPT PAD WITH THE BELT ITSELF OR FILLER STRIPS)

NOTES

- *1 - AFTER TACK, RUN A SMALL BEAD OF SILICONE ALONG TOP SEAM OF COVER
- *2 - CUT STRIPS OF BELT THE WIDTH OF THE CAVITY AND THE HEIGHT OF THE MEATCLEAT TO EVEN PRESSURE ON THE TOP COVER

PLEASE NOTE: All recommendations are for general use. Many factors come into play with splicing and must be considered; each piece of splicing equipment is different and may require the modification of settings to obtain the desired results.